

# Aero Design Ltd.

## Work Order Control Sheet

Work Order#: 2016-31 Date Opened: 26 Feb 2016 Title: Assembly

Aircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Cargo Basket Product Model: XL Ski Quantity: 1

### Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification	
Time Sheet (R&D)	N/A
Notes	N/A

### Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

### Drawing List

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket Assembly	JC
70405	4	Lid Walkway Mod.	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
84261	2	Handle Assembly	JC
94091	0	Basket Body Mod.	JC
94092	0	Lid Mod.	JC

### Traveller

	Initial or N/A
Install walkway on lid	JC
Install lid on basket body	JC
Re-tap mounting lug holes and install mount lugs	JC
Install handle brackets	JC
Install handle	JC
Install lid prop	JC
Install data plate	JC

Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Print: J. Clarke

Print: J. Rekve

Print: J. Clarke

Sign: [Signature]

Sign: [Signature]

Sign: [Signature]

SCA: AD02

SCA: AD01

SCA: AD02

Date: 02-Mar-16

Date: 03-Mar-16

Date: 05 APR 2016

Approved Manufacturing Facility 73-04

Form 20/0/03

Rev. Original 23 Sep 2014

### Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

### Certification

	Initial or N/A
Form One Completed	JC
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

### Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

### Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2016-31-1</b>	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-31</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>94010-01</b>	<b>1</b>	<b>94001-57</b>	<b>New</b>	
12. Remarks <b>Modified with walkway on lid IAW DCL704; Modified with survey provision IAW dwg 94091 and 94092</b>						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12.  Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature <i>Jeff Clarke</i> AD02		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>05 Apr 2016</b>		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.  Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.  Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

*SAR*



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET LID No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 940018. 94012-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-01

Remaining Tasks to be Performed: POWDER COATING ✓ JE.

Signature: [Signature]

Date: 12 FEB 2016 Lic. No. / SCA AD 02

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

### Remarks

MODIFIED IAW 94092





## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 94011-01 Serial/Batch No.: NSN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-01

Remaining Tasks to be Performed: POWDER COATING ✓ JF.

Signature: [Signature] CAL.

Date: 12 Feb 2016 Lic. No. / SCA AD 02

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### Remarks

In Process

MODIFIED IAW 94091



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 25  
PN: MS20001P4-9600  
Aircraft: All  
Description: Hinge  
Supplier: GKN Bandy  
Color: N/A  
WO#: N/A

Model: All

PO# 15069



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 100  
PN: NAS1149FO363P  
Aircraft: All  
Description: Washer  
Supplier: Bisco  
Color: N/A  
WO#: N/A

Model: All

PO# 16005



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 100  
PN: CR3213-5-02  
Aircraft: Multiple  
Description: Rivet  
Supplier: Bisco Industries  
Color: N/A  
WO#: N/A

Model: Multiple

PO# 15086

**CHERRY AEROSPACE**  
SPS Fastener Division, a PCC Company

1224 E. Warner Ave. Box 2157  
Santa Ana, CA 92707-0157

ACCEPT NO SUBSTITUTES ®

FSCM 11815 CHERRYMAX®

04/07/14 - IR

Part Number

CR3213-5-02

CR3213PR-5-02

FAA-TSO-C146

FAA-TSO-C148

Lot Number

87936251

Hole Size

.160-.164

Grip Range

.063-.125

QTY:

100

ALSO IN FULL COMPLIANCE WITH THE FOLLOWING  
NON-TSO PART NUMBER(S)

627-510-9420

NAS9301BNS-5-02

MBBN3012L4002

CAN43078B5-2

ASNA0078A502

S2906-5-2

NAS9301B-5-02

M7885/2-5-02

B0207005-5-02

132269A502

**\* OSHA WARNING \***  
**DANGER**

CONTAINS CADMIUM  
A POTENTIAL CANCER HAZARD  
A V O D CREATING DUST OR FUMES  
CAN CAUSE LUNG OR KIDNEY DISEASE

**\* NOTICE \***

THESE COMPONENTS ARE NOT REGULATED  
BY THE DEPT. OF TRANS. (DOT)



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 100  
PN: AN3-11A  
Aircraft: Multiple  
Description: Bolt  
Supplier: Aviall  
Color: N/A  
WO#: N/A

Model: Multiple

PO# 14048





WO# 2016-31

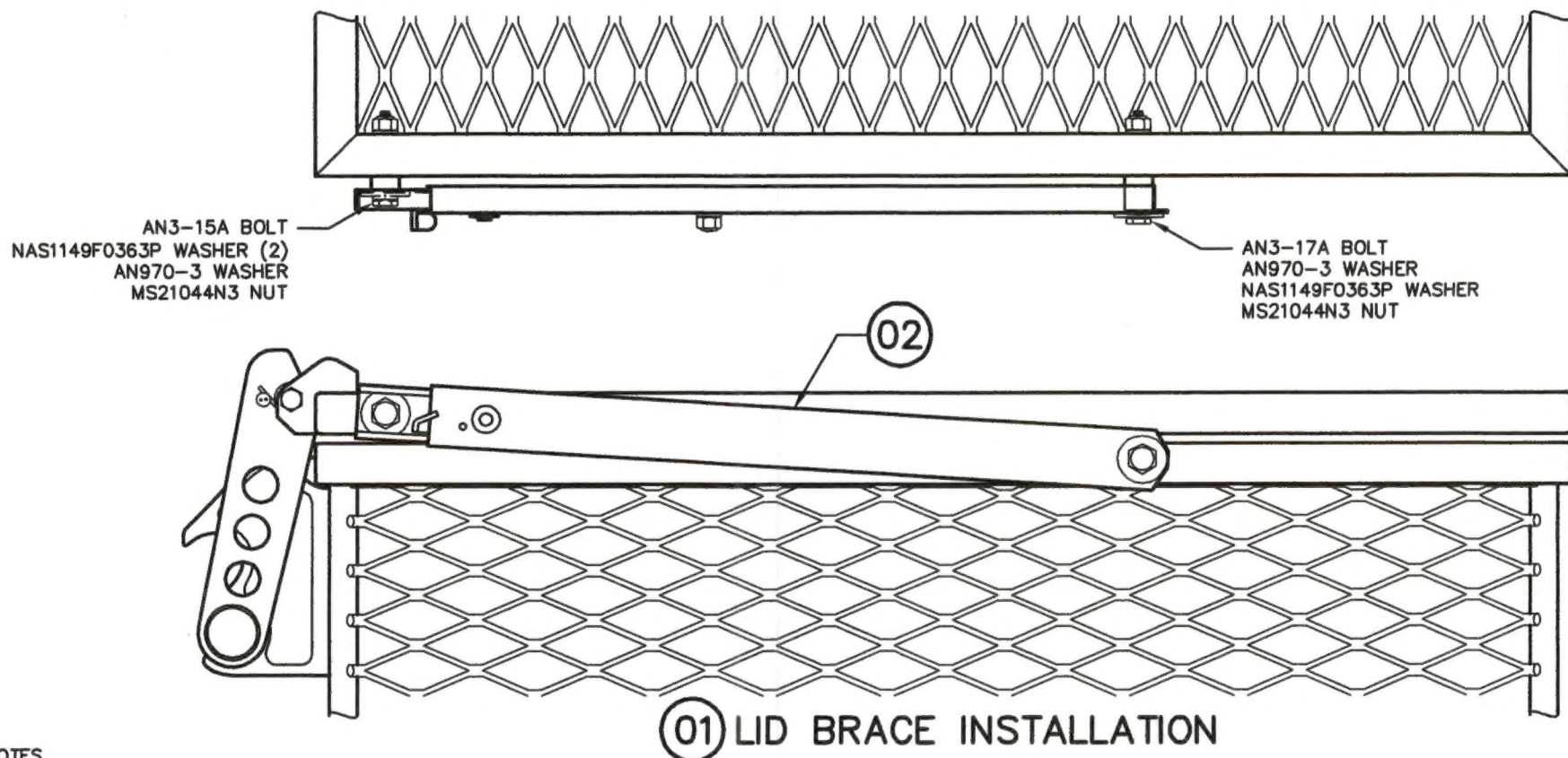
Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013

2016-31

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

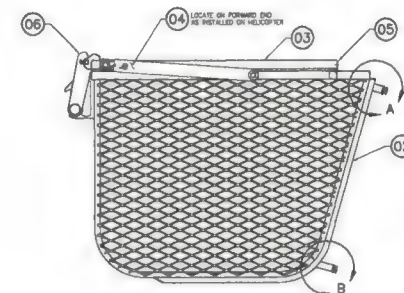
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2" X.XX ±0.03 X.X ±0.1	

		<b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 904.683.2376      www.aerodesign.ca	
		<b>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</b>	
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0



REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK ADD ALTERNATE INVENT. HARDWARE P/N'S UPDATED	BUC	1/6/78
CHANGE BRACKET ASSEMBLY TO INSTALLATION			



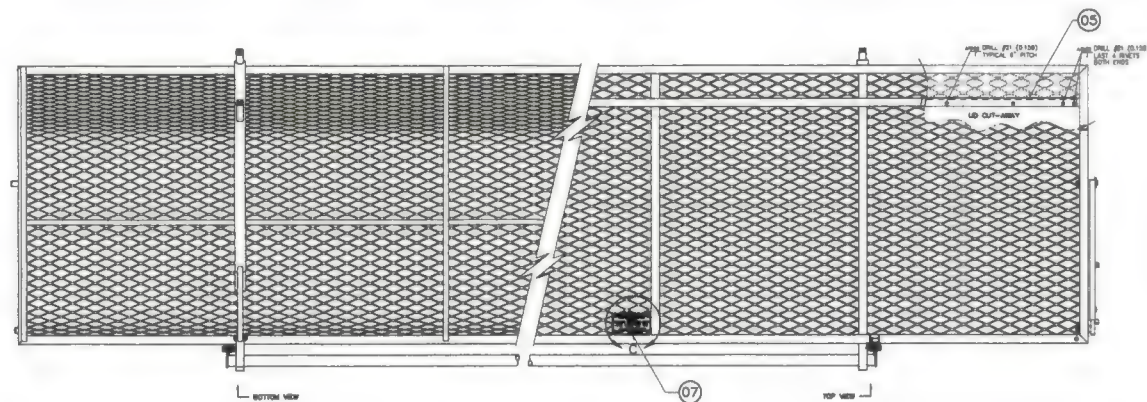
DETAIL A  
SCALE 1 : 2  
TYPICAL FRONT AND REAR



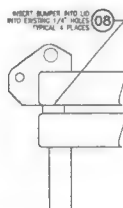
DETAIL B

SCALE 1/2"

TYPICAL FRONT AND REAR



940  
10  
-01 CARGO BASKET ASSEMBLY - RH



### BUMPER INSTALLATION



DETAIL C  
SCALE 1" = 1'  
LOOKING AT PLACARD BRACKET

A/N	WARRANT/DESCRIPTION	NUMBER	ALTERNATE	ANALYST CODES-1-4
6	BE PFC-01	PFC00		
7	CR2123-1-01	CR2123-1-01	ALTERNATE	ANALYST 000023-00
8	CR2123-1-02	CR2123-1-02	ALTERNATE	ANALYST 000023-01
9	CR2123-1-03	CR2123-1-03	ALTERNATE	ANALYST 000023-02
10	CR2123-1-04	CR2123-1-04	ALTERNATE	ANALYST 000023-03
11	CR2123-1-05	CR2123-1-05	ALTERNATE	ANALYST 000023-04
12	CR2123-1-06	CR2123-1-06	ALTERNATE	ANALYST 000023-05
13	CR2123-1-07	CR2123-1-07	ALTERNATE	ANALYST 000023-06
14	CR2123-1-08	CR2123-1-08	ALTERNATE	ANALYST 000023-07
15	CR2123-1-09	CR2123-1-09	ALTERNATE	ANALYST 000023-08
16	CR2123-1-10	CR2123-1-10	ALTERNATE	ANALYST 000023-09
17	CR2123-1-11	CR2123-1-11	ALTERNATE	ANALYST 000023-10
18	CR2123-1-12	CR2123-1-12	ALTERNATE	ANALYST 000023-11
19	CR2123-1-13	CR2123-1-13	ALTERNATE	ANALYST 000023-12
20	CR2123-1-14	CR2123-1-14	ALTERNATE	ANALYST 000023-13
21	CR2123-1-15	CR2123-1-15	ALTERNATE	ANALYST 000023-14
22	CR2123-1-16	CR2123-1-16	ALTERNATE	ANALYST 000023-15
23	CR2123-1-17	CR2123-1-17	ALTERNATE	ANALYST 000023-16
24	CR2123-1-18	CR2123-1-18	ALTERNATE	ANALYST 000023-17
25	CR2123-1-19	CR2123-1-19	ALTERNATE	ANALYST 000023-18
26	CR2123-1-20	CR2123-1-20	ALTERNATE	ANALYST 000023-19
27	CR2123-1-21	CR2123-1-21	ALTERNATE	ANALYST 000023-20
28	CR2123-1-22	CR2123-1-22	ALTERNATE	ANALYST 000023-21
29	CR2123-1-23	CR2123-1-23	ALTERNATE	ANALYST 000023-22
30	CR2123-1-24	CR2123-1-24	ALTERNATE	ANALYST 000023-23
31	CR2123-1-25	CR2123-1-25	ALTERNATE	ANALYST 000023-24
32	CR2123-1-26	CR2123-1-26	ALTERNATE	ANALYST 000023-25
33	CR2123-1-27	CR2123-1-27	ALTERNATE	ANALYST 000023-26
34	CR2123-1-28	CR2123-1-28	ALTERNATE	ANALYST 000023-27
35	CR2123-1-29	CR2123-1-29	ALTERNATE	ANALYST 000023-28
36	CR2123-1-30	CR2123-1-30	ALTERNATE	ANALYST 000023-29
37	CR2123-1-31	CR2123-1-31	ALTERNATE	ANALYST 000023-30
38	CR2123-1-32	CR2123-1-32	ALTERNATE	ANALYST 000023-31
39	CR2123-1-33	CR2123-1-33	ALTERNATE	ANALYST 000023-32
40	CR2123-1-34	CR2123-1-34	ALTERNATE	ANALYST 000023-33
41	CR2123-1-35	CR2123-1-35	ALTERNATE	ANALYST 000023-34
42	CR2123-1-36	CR2123-1-36	ALTERNATE	ANALYST 000023-35
43	CR2123-1-37	CR2123-1-37	ALTERNATE	ANALYST 000023-36
44	CR2123-1-38	CR2123-1-38	ALTERNATE	ANALYST 000023-37
45	CR2123-1-39	CR2123-1-39	ALTERNATE	ANALYST 000023-38
46	CR2123-1-40	CR2123-1-40	ALTERNATE	ANALYST 000023-39
47	CR2123-1-41	CR2123-1-41	ALTERNATE	ANALYST 000023-40
48	CR2123-1-42	CR2123-1-42	ALTERNATE	ANALYST 000023-41
49	CR2123-1-43	CR2123-1-43	ALTERNATE	ANALYST 000023-42
50	CR2123-1-44	CR2123-1-44	ALTERNATE	ANALYST 000023-43
51	CR2123-1-45	CR2123-1-45	ALTERNATE	ANALYST 000023-44
52	CR2123-1-46	CR2123-1-46	ALTERNATE	ANALYST 000023-45
53	CR2123-1-47	CR2123-1-47	ALTERNATE	ANALYST 000023-46
54	CR2123-1-48	CR2123-1-48	ALTERNATE	ANALYST 000023-47
55	CR2123-1-49	CR2123-1-49	ALTERNATE	ANALYST 000023-48
56	CR2123-1-50	CR2123-1-50	ALTERNATE	ANALYST 000023-49
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58	CR2123-1-52	CR2123-1-52	ALTERNATE	ANALYST 000023-51
59	CR2123-1-53	CR2123-1-53	ALTERNATE	ANALYST 000023-52
60	CR2123-1-54	CR2123-1-54	ALTERNATE	ANALYST 000023-53
61	CR2123-1-55	CR2123-1-55	ALTERNATE	ANALYST 000023-54
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63	CR2123-1-57	CR2123-1-57	ALTERNATE	ANALYST 000023-56
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67	CR2123-1-61	CR2123-1-61	ALTERNATE	ANALYST 000023-60
68	CR2123-1-62	CR2123-1-62	ALTERNATE	ANALYST 000023-61
69	CR2123-1-63	CR2123-1-63	ALTERNATE	ANALYST 000023-62
70	CR2123-1-64	CR2123-1-64	ALTERNATE	ANALYST 000023-63
71	CR2123-1-65	CR2123-1-65	ALTERNATE	ANALYST 000023-64
72	CR2123-1-66	CR2123-1-66	ALTERNATE	ANALYST 000023-65
73	CR2123-1-67	CR2123-1-67	ALTERNATE	ANALYST 000023-66
74	CR2123-1-68	CR2123-1-68	ALTERNATE	ANALYST 000023-67
75	CR2123-1-69	CR2123-1-69	ALTERNATE	ANALYST 000023-68
76	CR2123-1-70	CR2123-1-70	ALTERNATE	ANALYST 000023-69
77	CR2123-1-71	CR2123-1-71	ALTERNATE	ANALYST 000023-70
78	CR2123-1-72	CR2123-1-72	ALTERNATE	ANALYST 000023-71
79	CR2123-1-73	CR2123-1-73	ALTERNATE	ANALYST 000023-72
80	CR2123-1-74	CR2123-1-74	ALTERNATE	ANALYST 000023-73
81	CR2123-1-75	CR2123-1-75	ALTERNATE	ANALYST 000023-74
82	CR2123-1-76	CR2123-1-76	ALTERNATE	ANALYST 000023-75
83	CR2123-1-77	CR2123-1-77	ALTERNATE	ANALYST 000023-76
84	CR2123-1-78	CR2123-1-78	ALTERNATE	ANALYST 000023-77
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89	CR2123-1-83	CR2123-1-83	ALTERNATE	ANALYST 000023-82
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96	CR2123-1-90	CR2123-1-90	ALTERNATE	ANALYST 000023-89
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117	CR2123-1-111	CR2123-1-111	ALTERNATE	ANALYST 000023-110
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119	CR2123-1-113	CR2123-1-113	ALTERNATE	ANALYST 000023-112
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121	CR2123-1-115	CR2123-1-115	ALTERNATE	ANALYST 000023-114
122	CR2123-1-116	CR2123-1-116	ALTERNATE	ANALYST 000023-115
123	CR2123-1-117	CR2123-1-117	ALTERNATE	ANALYST 000023-116
124	CR2123-1-118	CR2123-1-118	ALTERNATE	ANALYST 000023-117
125	CR2123-1-119	CR2123-1-119	ALTERNATE	ANALYST 000023-118
126	CR2123-1-120	CR2123-1-120	ALTERNATE	ANALYST 000023-119
127	CR2123-1-121	CR2123-1-121	ALTERNATE	ANALYST 000023-120
128	CR2123-1-122	CR2123-1-122	ALTERNATE	ANALYST 000023-121
129	CR2123-1-123	CR2123-1-123	ALTERNATE	ANALYST 000023-122
130	CR2123-1-124	CR2123-1-124	ALTERNATE	ANALYST 000023-123
131	CR2123-1-125	CR2123-1-125	ALTERNATE	ANALYST 000023-124
132	CR2123-1-126	CR2123-1-126	ALTERNATE	ANALYST 000023-125
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134	CR2123-1-128	CR2123-1-128	ALTERNATE	ANALYST 000023-127
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136	CR2123-1-130	CR2123-1-130	ALTERNATE	ANALYST 000023-129
137	CR2123-1-131	CR2123-1-131	ALTERNATE	ANALYST 000023-130
138	CR2123-1-132	CR2123-1-132	ALTERNATE	ANALYST 000023-131
139	CR2123-1-133	CR2123-1-133	ALTERNATE	ANALYST 000023-132
140	CR2123-1-134	CR2123-1-134	ALTERNATE	ANALYST 000023-133
141	CR2123-1-135	CR2123-1-135	ALTERNATE	ANALYST 000023-134
142	CR2123-1-136	CR2123-1-136	ALTERNATE	ANALYST 000023-135
143	CR2123-1-137	CR2123-1-137	ALTERNATE	ANALYST 000023-136
144	CR2123-1-138	CR2123-1-138	ALTERNATE	ANALYST 000023-137
145	CR2123-1-139	CR2123-1-139	ALTERNATE	ANALYST 000023-138
146	CR2123-1-140	CR2123-1-140	ALTERNATE	ANALYST 000023-139
147	CR2123-1-141	CR2123-1-141	ALTERNATE	ANALYST 000023-140
148	CR2123-1-142	CR2123-1-142	ALTERNATE	ANALYST 000023-141
149	CR2123-1-143	CR2123-1-143	ALTERNATE	ANALYST 000023-142
150	CR2123-1-144	CR2123-1-144	ALTERNATE	ANALYST 000023-143
151	CR2123-1-145	CR2123-1-145	ALTERNATE	ANALYST 000023-144
152	CR2123-1-146	CR2123-1-146	ALTERNATE	ANALYST 000023-145
153	CR2123-1-147	CR2123-1-147	ALTERNATE	ANALYST 000023-146
154	CR2123-1-148	CR2123-1-148	ALTERNATE	ANALYST 000023-147
155	CR2123-1-149	CR2123-1-149	ALTERNATE	ANALYST 000023-148
156	CR2123-1-150	CR2123-1-150	ALTERNATE	ANALYST 000023-149
157	CR2123-1-151	CR2123-1-151	ALTERNATE	ANALYST 000023-150
158	CR2123-1-152	CR2123-1-152	ALTERNATE	ANALYST 000023-151
159	CR2123-1-153	CR2123-1-153	ALTERNATE	ANALYST 000023-152
160	CR2123-1-154	CR2123-1-154	ALTERNATE	ANALYST 000023-153
161	CR2123-1-155	CR2123-1-155	ALTERNATE	ANALYST 000023-154
162	CR2123-1-156	CR2123-1-156	ALTERNATE	ANALYST 000023-155
163	CR2123-1-157	CR2123-1-157	ALTERNATE	ANALYST 000023-156
164	CR2123-1-158	CR2123-1-158	ALTERNATE	ANALYST 000023-157
165	CR2123-1-159	CR2123-1-159	ALTERNATE	ANALYST 000023-158
166	CR2123-1-160	CR2123-1-160	ALTERNATE	ANALYST 000023-159
167	CR2123-1-161	CR2123-1-161	ALTERNATE	ANALYST 000023-160
168	CR2123-1-162	CR2123-1-162	ALTERNATE	ANALYST 000023-161
169	CR2123-1-163	CR2123-1-163	ALTERNATE	ANALYST 000023-162
170	CR2123-1-164	CR2123-1-164	ALTERNATE	ANALYST 000023-163
171	CR2123-1-165	CR2123-1-165	ALTERNATE	ANALYST 000023-164
172	CR2123-1-166	CR2123-1-166	ALTERNATE	ANALYST 000023-165
173	CR2123-1-167	CR2123-1-167	ALTERNATE	ANALYST 000023-166
174	CR2123-1-168	CR2123-1-168	ALTERNATE	ANALYST 000023-167
175	CR2123-1-169	CR2123-1-169	ALTERNATE	ANALYST 000023-168
176	CR2123-1-170	CR2123-1-170	ALTERNATE	ANALYST 000023-169
177	CR2123-1-171	CR2123-1-171	ALTERNATE	ANALYST 000023-170
178	CR2123-1-172	CR2123-1-172	ALTERNATE	ANALYST 000023-171
179	CR2123-1-173	CR2123-1-173	ALTERNATE	ANALYST 000023-172
180	CR2123-1-174	CR2123-1-174	ALTERNATE	ANALYST 000023-173
181	CR2123-1-175	CR2123-1-175	ALTERNATE	ANALYST 000023-174
182	CR2123-1-176	CR2123-1-176	ALTERNATE	ANALYST 000023-175
183	CR2123-1-177	CR2123-1-177	ALTERNATE	ANALYST 000023-176
184	CR2123-1-178	CR2123-1-178	ALTERNATE	ANALYST 000023-177
185	CR2123-1-179	CR2123-1-179	ALTERNATE	ANAL

[illegible]

Technical drawing of a rectangular mesh assembly, likely a filter or screen, showing dimensions and construction details.

**Dimensions:**

- Overall width: 75
- Overall height: 75
- Inner rectangular area: 53 (width) x 60 (height)
- Minimum radius: MIN R0.06 TYP

**Callouts and Details:**

- 03:** 2 PLACES (03) - Points to the top and bottom edges of the inner rectangular area.
- 04:** (04) - Points to the bottom edge of the inner rectangular area.
- GTAW BOTH ENDS:** Points to the top and bottom edges of the inner rectangular area.
- 0.1 SETBACK ON ENDS:** Points to the top and bottom edges of the inner rectangular area.
- DRILL #30 (0.129) CENTRE RIVETS ON TUBES SPOT FACE #0.25 IF REQ:** Points to the top and bottom edges of the inner rectangular area.
- 0.19 MIN TYP:** Points to the top and bottom edges of the inner rectangular area.
- 53 TREAD PLATE:** Points to the top and bottom edges of the inner rectangular area.
- 6-0 TUBES:** Points to the top and bottom edges of the inner rectangular area.
- RUN BEAD OF COMMERCIAL RTV SILICONE SEALANT ALONG ALL TUBES BELOW TREAD PLATE BEFORE INSTALLATION:** Points to the top and bottom edges of the inner rectangular area.





## SECTION A-A

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCEPT A5350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCEPT EC135 MCDONNELL DOUGLAS M60600, BELL 2088 BASKETS	BJC	DEC 4/08
3	ADD NEW A5350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALI RVET, ADD NOTE 7	BJC	26/05/2011

NOTES

- 1 THIS DRAWING IS AN OPTIONAL CONFIGURATION ADJUST A TREAD PLATE STEP TO THE LID  
THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID REMAINDER OF  
LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS
- 2 TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM
- 3 REMOVE ALL BURRS AND BRUISES FROM TUBES
- 4 WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C  
WELDING ROD SHALL CONFORM TO E70TS-2 OR EQUIVALENT
- 5 WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
- 6 THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLY PRIOR TO ASSEMBLY.  
MESH TREAD PLATE AND ROSETTE COATING
- 7 WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED  
IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID

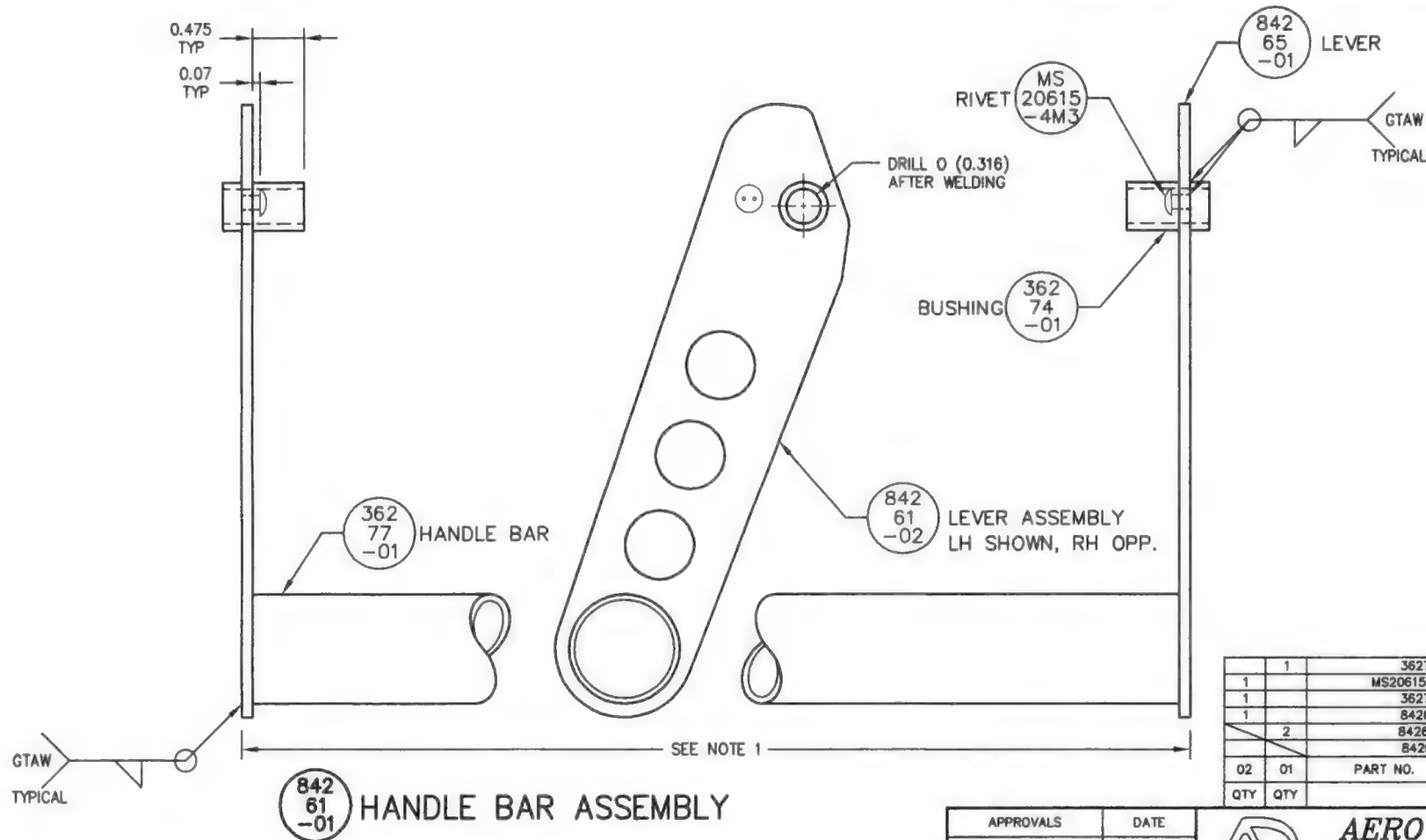
A/R	CR3213-4-02	BLIND RIVET	ALTERNATE	HR3213-4-02	
1	70405-04	04 TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03 TUBE	4130 STEEL COND N	MIL-T-8738	0.5 X 0.035 WALL TUBE
1	SEE NOTE	02 BASKET LID			
	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP			
Q1	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY	LIST OF MATERIALS				

BASIC CODE REF NAS 523		DASH NO. FOR DIAMETER W=WFED HEAD NEAR SIDE F=WFED HEAD FAR SIDE		APPROVALS DRAWN: JEFF CLARKE 21 SEP 2008 CHECKED: E BURGION		DATE		 AERO DESIGN LTD. 9886A MALAPASCUA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604-684-5275    www.aerodesign.ca					
C=COUNTERSINK D=DRILL DGT=# of SHEETS TO BE DRILLED		DASH NO. FOR LENGTH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		CARGO BASKET LID STEP MODIFICATION							
BASIC CODES: BJ=M204070AD BR=M2042RAD ARW=CR 3213 ARW=CR 3212		 INSTALL NEW RIVET  REMOVE/REPLACE RIVET  EXISTING RIVET		DECIMALS      ANGLES X XX ±0.010      ±1/2° X XX ±0.03 X X ±0.1		SCALE 1 : 5 SHEET 1 OF 1		DWG SIZE A1		DWG NO 70405		REV 4	

2016-31

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



## NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1	1	MS20615-4M3	RIVET (MONEL)
1	1	36274-01	BUSHING
1	1	84265-01	LEVER
2	2	84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



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HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY

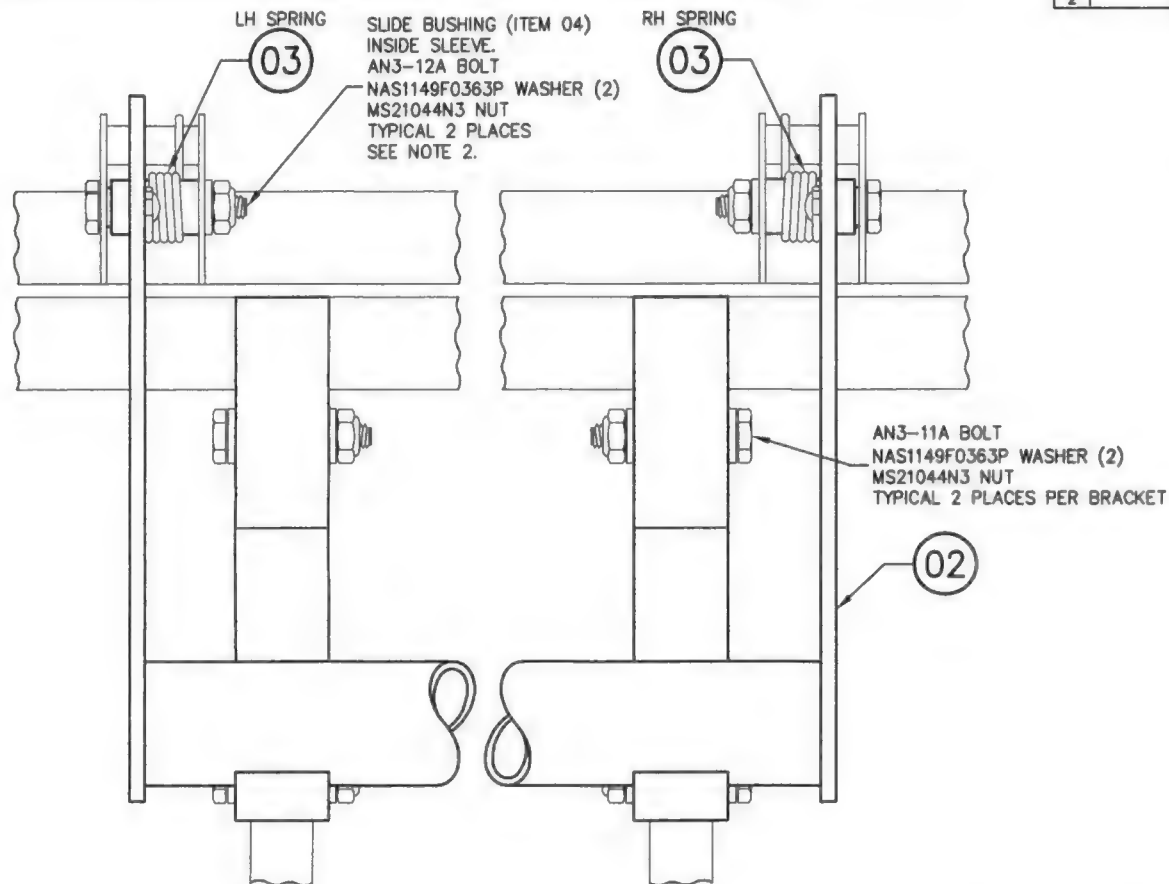
SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			



2016-31

## NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.

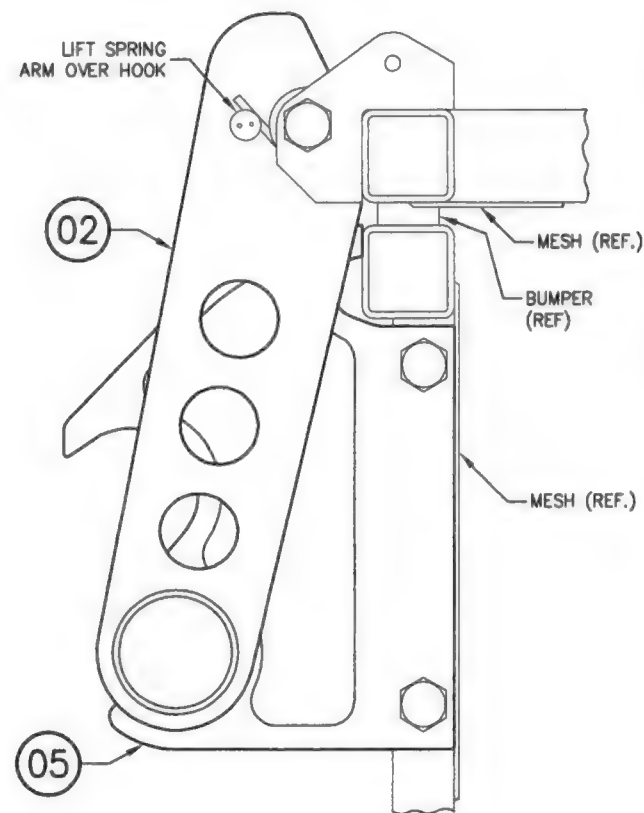


# 01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
8	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14



APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



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### HELICOPTER CARGO BASKET HANDLE BAR INSTALLATION

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

## Aero Design

### Parts Distribution Sheet

Description: AS380 XL ASS'Y

WO# 2016-31

[illegible]

## CARGO BASKET ASSEMBLY - COMMON

2016-31

AS 350 XL

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355** – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

→ 94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44** – left or right

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429** – right or left

95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### Options

→ 70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-31

Date Open: 26 FEB 2016

AD02

### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

AD02

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

A002

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



- d. Record PO of hinge and rivets on attached material tracking list.

**4. Install Handle**

AD02

**a. Install handle brackets.**

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

**b. Install handle**

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

**c. Check handle**

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

**5. Install lid brace**

AD02

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

**CARGO BASKET ASSEMBLY - COMMON**

**Complete**  
(initial or SCA #)



**6. Final Inspection**

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-31

Complete  
(initial or SCA #)

Date Open: 26 Feb 2016

2015-122

1. Weld Lever Assembly – handle lever jig required
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

2. Clean up
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

3. Fabricate Handle Assembly
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

4. Weld Handle Assembly
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up
  - a. Clean welded area with scotch-brite.

6. Final Inspection –

To be completed by a different person than the previous steps.

  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.



Work Order: 2016-31Date Opened: 26 FEB 2016

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94010-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		
						<i>S/N 94001-57</i>
Step 1.a.	. 1		94012-01	Basket Lid Assembly		<i>2016-01</i>
	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	. . 4		CR3213-4-02	Cherry Rivet		<i>15031</i>
Step 1.c. (option)	. 1		70405-01	Lid Step Modification		
	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<i>15056</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15031</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		94011-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<i>2016-01</i>
	. . 8		AN960-616	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<i>15069</i>
	<i>8 R/C</i>		CR3523-5-02	Cherry Rivet		<i>16005</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>15086</i>
<b>Step 4</b>	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2015-02</i>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

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Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		See attached
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2016-32
	. 1		AN3-15A	Bolt		14084
	. 1		AN3-17A	Bolt		15031
	. 2		AN970-3	Washer		15014
	. 3		NAS1149F0363P	Washer		16005
	. 2		MS21044N3	Nut		15031
Step 6				Inspection	None	



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Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	84261	84261-01	Handle Assembly		
Step 1				Weld Lever Assembly		WO 2015-122
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
Step 2				Clean Up	None	
Step 3				Fabricate Handle Bar		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	15073
Step 4				Weld Handle Assembly	None - Fuse weld, no rod req.	TX.
Step 5				Clean Up	None	
Step 6				Inspection - Final Assembly	None	